

# Work Order ID 69847

Friday, May 20, 2011 10:37:14 AM



Page 1

Item ID: D4038-4

Accept



Setup Start



Revision ID:

Item Name: Angle, Aft, RH

Stop



Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *11/05/20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4038

D L/R

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank 7.625" long

0.00

*cut 11/06/07*

*2*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: *E*

Folio Rev: *AA*

Deburr

0.00

*SL 11/06/08*

*(2)*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69847



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Item ID: D4038-4

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Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, RH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 JL 11/06/08 0.00				2	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 B.A 11/06/08 0.00				2	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				2	0		MA 11/06/09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69847**

Friday, May 20, 2011 10:37:14 AM

Page 3

Item ID: D4038-4

Accept

Revision ID:

Item Name: Angle, Aft, RH

Start Date: 5/20/2011 Start Qty: 2.00

Required Date: 6/10/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2	0	11-6-9.	
160 Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00  0.00						11/06/09 (2)	
170 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						11/6/09 MF 11-06-09	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Friday, May 20, 2011 10:37:12 AM

Page 1

Work Order ID: 69847



Parent Item: D4038-4



Parent Item Name: Angle, Aft, RH



Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	21.2845	0.7	1.473684			
 													

6061T6 ANGLE 4.00 x 4.00 x .250

Location	Loc Qty	Loc Code
MAT006	20	
117285	20	
MAT007	1.2845	
114507	1.2845	

1.473 5/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 69847
Description: Angle, AFH, R-H		Part Number: D4038-4
Inspection Dwg: D4038, Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+0.030	3.995	✓		VIM JLS	
1.250	+0.030	1.250	✓		"	
1.25	+0.030	1.245	✓		"	
4.00	+0.030	3.995	✓		"	
.250	+0.010	.247	✓		"	
1.25	+0.030	.250	✓		"	
.581	+0.010	.581	✓		"	
.669	+0.010	.669	✓		H-G	
2.904	+0.010	2.904	✓		H-G	
.735	+0.010	.735	✓		H-G	
.500	+0.010	.500	✓		H-G	
2.00	+0.030	2.00	✓		"	
.500	+0.010	.500	✓		H-G	
Ø.316	+0.006 -0.001	.316	✓		"	
Ø.189	+0.005 -0.001	.190	✓		"	
1.3	+0.030	.130	✓			
.70	+0.030	.700	✓		"	
1.000	+0.010	1.000	✓		H-G	
1.500	+0.010	1.500	✓		"	
1.00	+0.030	1.00	✓		"	
1.19	+0.030	1.19	✓		"	
2.125	+0.010	2.125	✓		"	
.589	+0.010	.590	✓		"	

Measured by: JL
Date: 11/06/08

Audited by: B.A.
Date: 11/06/08

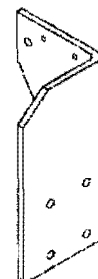
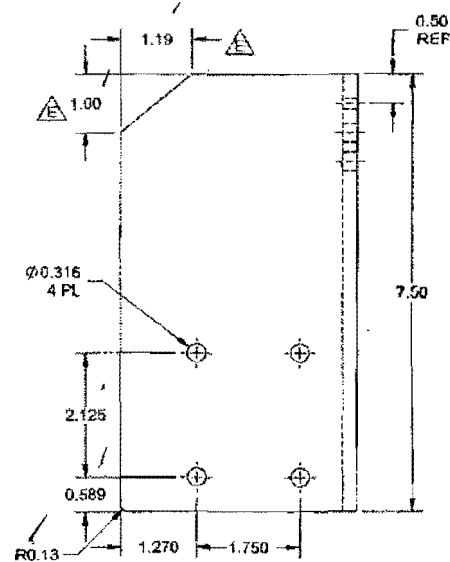
Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	









69847

RELEASED  
2011-04-21

## NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		<b>D4038</b>	SHEET # OF
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	N/T
DATE	<b>11.04.11</b>	COPYRIGHT © 2003 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS UNCLASSIFIED AND NOT CONTROLLED UNDER THE ACCESS TO INFORMATION ACT / LE DOCUMENT EST NON CLASSÉ ET N'EST PAS CONTRÔLÉ EN VERTU DE LA LOI SUR L'ACCÈS À L'INFORMATION</small>	

